G CODE

; Ender 3 Custom Start G-code

G92 E0 ; Reset Extruder

G28 ; Home all axes

G1 Z2.0 F3000 ; Move Z Axis up little to prevent scratching of Heat Bed

G1 X0.1 Y20 Z0.3 F5000.0 ; Move to start position

G1 X0.1 Y200.0 Z0.3 F1500.0 E15 ; Draw the first line

G1 X0.4 Y200.0 Z0.3 F5000.0 ; Move to side a little

G1 X0.4 Y20 Z0.3 F1500.0 E30 ; Draw the second line

G92 E0 ; Reset Extruder

G1 Z2.0 F3000 ; Move Z Axis up little to prevent scratching of Heat Bed

G1 X5 Y20 Z0.3 F5000.0 ; Move over to prevent blob squish

G0 si muove senza estrudere

G1 si muove con l’estrusore

G90 set posizione assoluta

G91 set posizione relativa

G28 auto home

M104

M109

M140

M190